

Work Order ID 72636

Wednesday, August 03, 2011 12:46:28 PM



Page 1

Item ID: D4020-11

Accept



Setup Start



Revision ID:

Item Name: End Mesh, Basket

Stop



Start Date: 8/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/10/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11-08-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4020

A

100

0.00



FLOW WATER JET

0.00

Handwritten signature 11/08/11

6

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D4020

Dwg Rev: *Handwritten A*

Prog Rev: *Handwritten A*

2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

Handwritten signature 11/08/11

6

QC

Memo

Quality Control

CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET

120

0.00



QC8- Inspect parts - second check

0.00

Handwritten signature 11/08/11

Handwritten signature

QC

Memo

Quality Control

CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop



Item Name: End Mesh, Basket

Start Date: 8/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/10/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: *B/C*

0.00

Memo

0.00

SK/PMB 11/08/31

Packaging

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/9/6 JH
MF 11-09-a

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Picklist Print

Wednesday, August 03, 2011 12:47:21 PM

Page 1

Work Order ID: 72636



Parent Item: D4020-11



Parent Item Name: End Mesh, Basket

Start Date: 8/3/2011

Required Date: 8/10/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.26 verified by;EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 10.06.14 remove
cut out from dxf, will be made when install on basket DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304EX0.75-16F

Purchased

No

100

sf

723.2433

2.694

17.01474



Expanded Metal Flat SS

Location

Loc Qty

Loc Code

MAT

11.5607

117708

11.5607

WA

711.6826

115012

95

117197

102.9036

117455

16.0341

117896

53.3264

118153

98.6394

118248

66.0983

118450

279.6808

17.2 11/08/11

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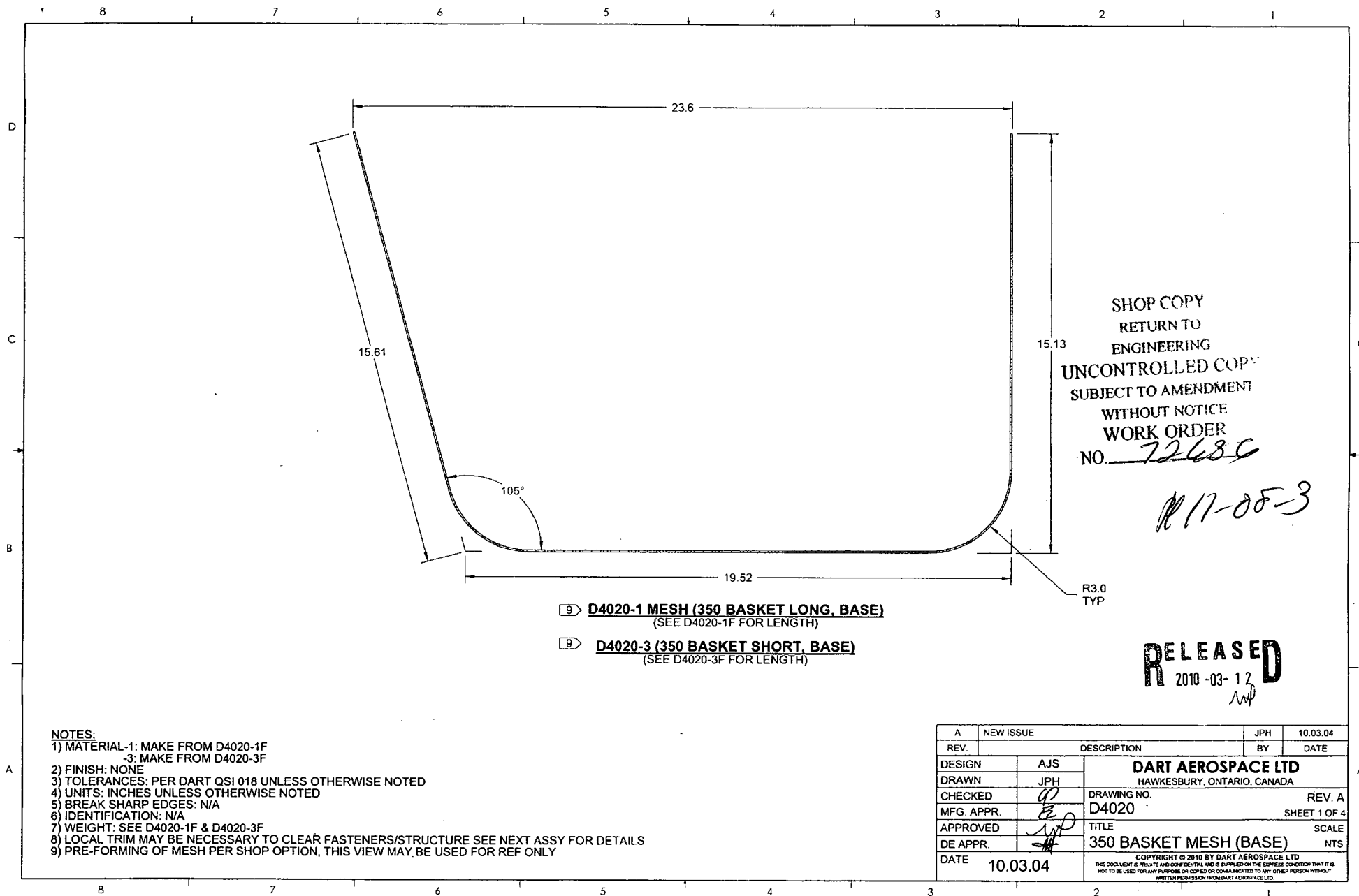
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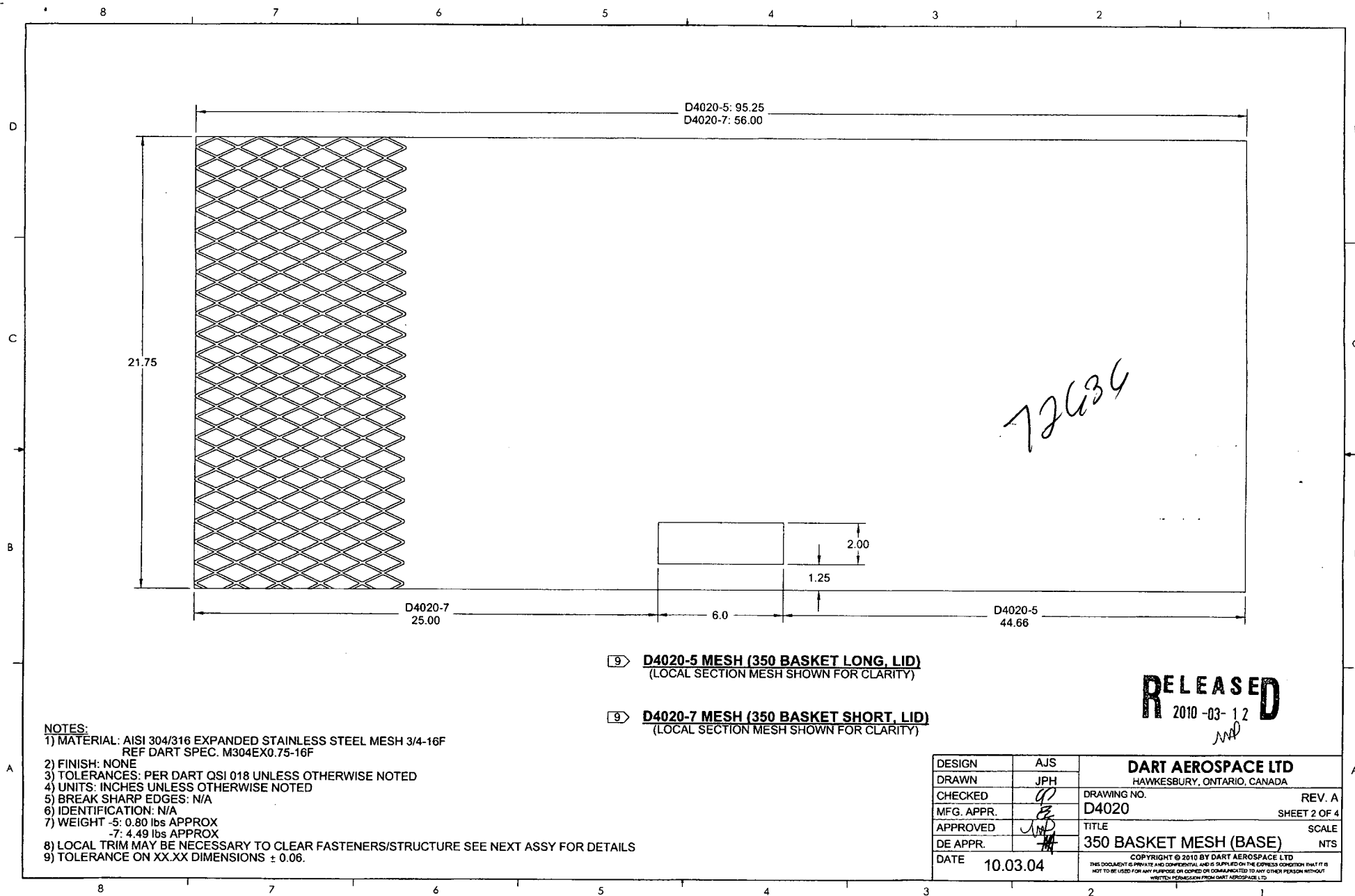
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RELEASED
2010-03-12
[Signature]

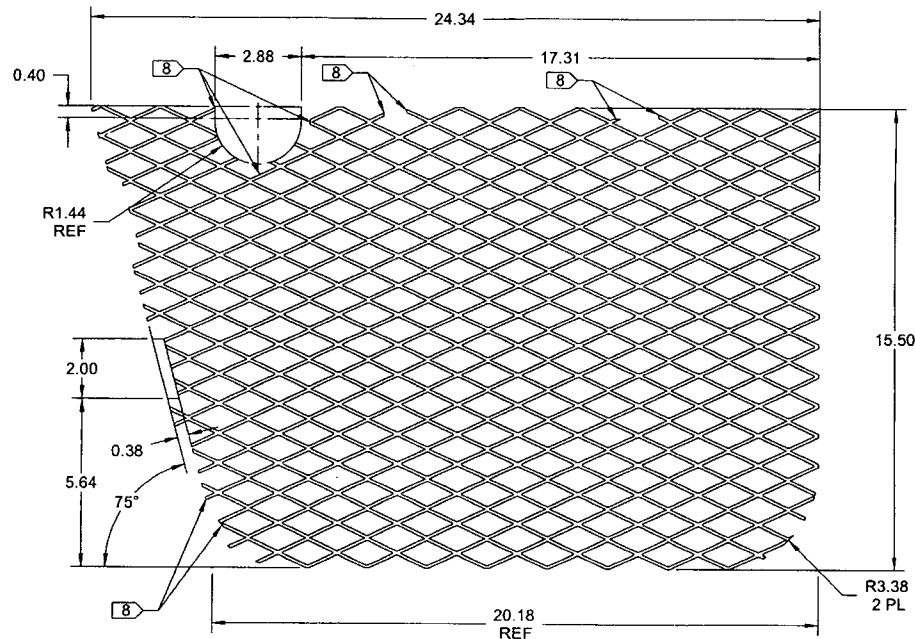
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9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO. D4020	REV. A
MFG. APPR.	JP	SHEET 3 OF 4	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

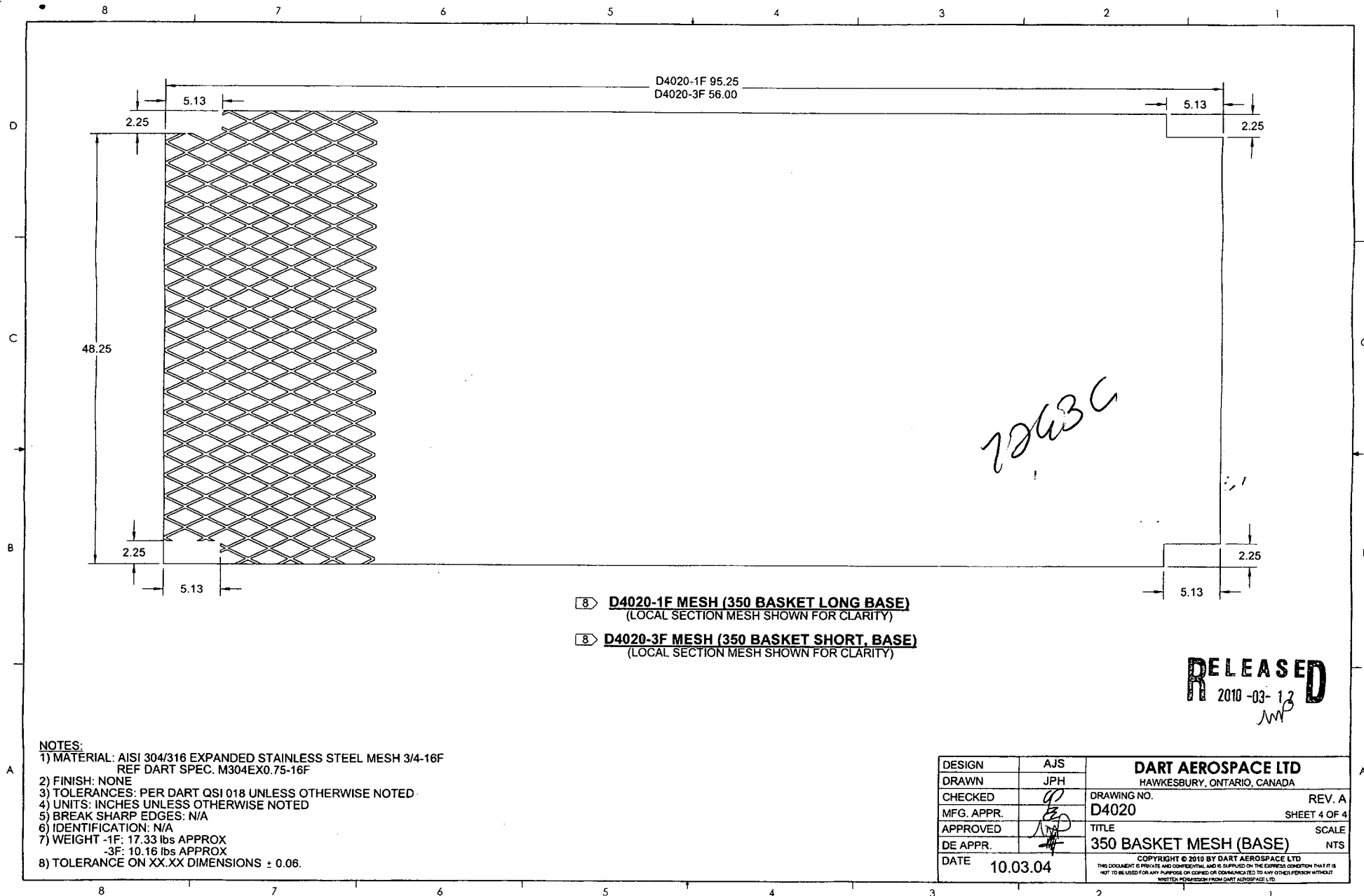
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- 8) **D4020-1F MESH (350 BASKET LONG BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)
- 8) **D4020-3F MESH (350 BASKET SHORT, BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
R 2010-03-13
MW

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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